

Work Order ID 63797

Monday, November 15, 2010 8:31:06 AM



Page 1

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date:

10/11/15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

*8/01/2/02**CK per BG 10/11/16*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/11/25 (2) SD

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8/01/2/02**(+2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-588-011								
	Location: <u>22</u>								
	PPP Rev: <u>C</u>								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

10/12/3 (2) (2x)

OK 10/12/00
10-12-3
(2)

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Work Order ID: 63797

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification



Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

46.0000

2

4

10/11/25

SP



Screw

Location

Loc Qty

Loc Code

ST328

46

113064

1

113749

1

114056

44

AN526C832R8

Purchased

No

120

Each

132.0000

8

16

10/11/25

SP



Screw

Location

Loc Qty

Loc Code

ST327

132

114615

32

114718

100

AN526C832R9

Purchased

No

120

Each

149.0000

8

16

10/11/25

SP 24



Screw

Location

Loc Qty

Loc Code

ST327

149

115422

3

115835

46

115936

100

W/O:		WORK ORDER CHANGES					
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Work Order ID: 63797

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

AN960JD10 NAS1149D0363J Purchased No

120 Each

8.0000

4

8



Washer



M115622 10/11/25

9

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD8 NAS1149DN832 J Purchased No

120 Each

10.0000

24

48



Washer



M115996 10/11/25 SP

Location

Loc Qty

Loc Code

ST347

10

105059

10

D2143 Manufactured No

120 Each

10.0000

1

2



Hinge Bracket



10/11/25 S

SP

Location

Loc Qty

Loc Code

ST198

10

55323

10

D2144 Manufactured No

120 Each

35.0000

1



Hinge Bracket



10/11/25 SP (2x)

Location

Loc Qty

Loc Code

ST198

35

55179

35

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Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 63797

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

Sa D2150
Packer Doubler, Hinge

Manufactured No 120 Each 20.0000

2
Barcode

4
10/11/25 sf

Location Loc Qty Loc Code

ST007 20
55178 20

Sa D2151
Packer Doubler, Hinge

Manufactured No 120 Each 43.0000

2
Barcode

4
10/11/25 sf

Location Loc Qty Loc Code

ST007 43
55319 5
62246 38

Sa D2153
Door Prop

Manufactured No 120 Each 14.0000

1
Barcode

2
10/11/25 sf

Location Loc Qty Loc Code

ST272 14
59818 14

Sa D2154
Stud Bracket

Manufactured No 120 Each 6.0000

1
Barcode

2
10/11/25 sf 2x

Location Loc Qty Loc Code

ST007 6
55325 3
62479 3

2

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Work Order ID: 63797

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

D2237

Manufactured No

120 Each

52.0000

2

4



Striker Plate

Location

Loc Qty

Loc Code

ST009

5

60492

5

ST010

47

62212

47

D2461

Manufactured No

120

f

64.1872

7.25

15.26316



Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

64.18721053

39782

6.5

55054

57.6872105

cut 1 X 87.00"

D2463

Manufactured No

120

f

269.5105

7.25

15.26316



Seal

Location

Loc Qty

Loc Code

ST404

269.51053

55561

1.68

62597

267.83053

cut 1 X 87.00"

D2463

Manufactured No

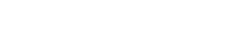
120

f

269.5105

7.25

15.26316



Seal

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 63797

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

D2583

Manufactured No

120

Each

10.0000

2

4



Latch Bracket



BC4080 10/12/2010 SP

Location

Loc Qty

Loc Code

ST017

8

61715

8

ST018

2

56527

2

21

D2585

Manufactured No

120

Each

50.0000

2

4



Mounting Channel



10/11/2010 SP

Location

Loc Qty

Loc Code

ST018

33

62676

33

ST019

17

59873

17

✓

D2586

Manufactured No

120

Each

51.0000

2

4



Door Latch



10/11/2010 SP

Location

Loc Qty

Loc Code

ST204

51

61655

51

✓

D2587

Manufactured No

120

Each

11.0000

1

2



Door Slug, 350 Hinge



10/11/2010 SP (2x)

Location

Loc Qty

Loc Code

ST019

11

56555

11

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 63797

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

D2589
Keys, Key Chain, 350 Hinge

Manufactured No

120 Each

161.0000

1

2

Location

Loc Qty

Loc Code

ST019

161

58194

161

120 Each

16.0000

1

2

D2690-17
Cable

Manufactured No

Location

Loc Qty

Loc Code

ST021

16

62480

16

120 Each

24.0000

1

2

D2857-1
Hinge Bracket

Manufactured No

Location

Loc Qty

Loc Code

ST026

24

56529

1

57924

23

120 Each

32.0000

1

2

D2857-2
Hinge Bracket

Manufactured No

Location

Loc Qty

Loc Code

ST027

32

55020

1

56530

7

57925

24

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 63797

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

D2858-1
Hinge Bracket

Manufactured No

120 Each

14.0000

1

2

Location

Loc Qty

Loc Code

ST027

14

56423

8

61522

6

D2858-2
Hinge Bracket

Manufactured No

120 Each

6.0000

1

2

Location

Loc Qty

Loc Code

ST027

6

61523

6

FG-778150-550-ROL
7781 9oz Glass 50"x125yd

Purchased No

120 sf

1,829.150

1

2

Location

Loc Qty

Loc Code

ST404

1829.15

108932

18

111166

397

113905

1414.15

1- cut 1 square ft of glass cloth

MS20426AD3-4
RIVET

Purchased No

120 Each

5,984.000

12

24

Location

Loc Qty

Loc Code

ST316

5984

104374

1984

110398

4000

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W/O:		WORK ORDER CHANGES					
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Page 8

Work Order ID: 63797

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

MS20470AD4-5

Purchased

No

120

Each

492.0000

18

36



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST309

455

114761

455

ST319

37

111916

37

10/11/25

36

MS21042L08

Purchased

No

120

Each

238.0000

18

36



Nut

Location

Loc Qty

Loc Code

ST300

238

115835

138

116082

100

10/11/25

30

MS21042L3

Purchased

No

120

Each

1,783.000

4

8



Nut

Location

Loc Qty

Loc Code

ST300

1783

114784

783

115835

1000

10/11/25

8

MS27039-08-11

Purchased

No

120

Each

41.0000

2

4



Screw

Location

Loc Qty

Loc Code

ST288

41

114382

41

10/11/25

4

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 63797

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-15

Purchased

No

120

Each

47.0000

2

4



Screw



10/11/25 sl (20)

Location

Loc Qty

Loc Code

ST292

47

114056

2

114718

45

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00